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D2873-045
Job Sheet 191089



Part No: D2873-045

Job Qty: 30 pcs

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	30 pcs		4/12/19	0.00	0.26	Bandsaw - 1		BA
110	HAAS 4 Axis - B4B	30 pcs		4/12/19	0.09	7.62	HAAS - 1 - B4B		mmL 19/03/19
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	30 pcs		4/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		mmL 19/03/19
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		



Container No: S159706



Part: D2873 - 045

Job No: 191089

Serial No/Batch: S159706

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/06/19

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130 QC 8	30 pcs	4/12/19	0.00 0.00	QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
140 Small Fab - 2 - B4B	30 pcs	4/12/19	0.00 0.84	QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
150 QC 5	30 pcs	4/12/19	0.00 0.00	Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
160 Handfinish - 1-1 Chemical-B4B	30 pcs	4/12/19	0.00 0.62	QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	

ml 19/03/12

					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R. 19/03/12
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170 QC 7	30 pcs	4/12/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	DAS
					QC 7 - 58	58 MAR 12 2019
					QC 7 - 59	9-89
					QC 7 - 6	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	DAS
180 Small Fab - 3 - B4B	30 pcs	4/12/19	0.00	0.84	Small Fab - 1 - B4B	58 MAR 12 2019
					Small Fab - 2 - B4B	9-89
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
190 QC 5	30 pcs	4/12/19	0.00	0.00	QC 5 - 10	

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					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	MAR 13 2019 DAS 40
					QC 5 - 50	9-89
					QC 5 - 30	
200	Packaging 3-1 - Stock - B4B	30 pcs	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	LG050 AB 17-3-23
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210	QC 21 - SA	30 pcs	4/12/19	0.00 0.00	QC 21 - SA - 21	DAS MAR 25 2019
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

Part Op 100 - (Bandsaw) Cut blanks: 1.000" x 0.375" x 2.700" long
 Descriptions: 110 - HAAS1-2 (HAAS CNC Vertical Machine) Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev
 F1819Folio Rev _____
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)

- 140 - (Small Fab) 1-Deburr
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Chemical Conversion Coat per QSI005 4.1)
 170 - (QC7-Inspect Chemical Conversion Coat)
 180 - (Small Fab) 1-Assemble as per Dwg D2873 2-Identify as D2873-045
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____) (Identify as per dwg & Stock Location: _____) LOCATION : LG050
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	6.7500 ft (.225 ea)	100-Bandsaw - 1	5150599
MS20426AD4-6	Rivet	120 Ea (4 ea)	180-Small Fab - 3 - B4B	5083538-1
MS21075L5	Nut Plate	60 Ea (2 ea)	180-Small Fab - 3 - B4B	5142061X12

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.375X1.000	7	23	0
180-Small Fab - 3 - B4B	MS20426AD4-6	120	1,249	0
	MS21075L5	60	239	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 191089
Description: Radius Block		Part Number: D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.500	/		vern	mml-05
1.000	+/-0.010	0.995	/			
0.750	+/-0.010	0.748	/			
0.250	+/-0.010	0.246	/			
1.000	+/-0.010	1.003	/			
2.000	+/-0.010	2.003	/			
Ø0.128	+0.005/-0.001	0.132	/			
0.359	+/-0.010	0.359	/			
Ø0.316	+0.006/-0.001	0.320	/			
1.000	+/-0.010	1.00	/			
0.250	+/-0.010	0.247	/			
0.061	+/-0.010	0.067	/			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.230 x 0.130	/			

Measured by: mml	Audited by:	Prototype Approval:	N/A
Date: 19/03/06	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					